

Split

Work Order ID 58350-1

Monday, May 10, 2010 3:14:31 PM



Item ID: D3643-2

Accept

Revision ID:

Item Name: Stiffener

Start Date: 5/4/2010 Start Qty: 10.00

Required Date: 5/6/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: MFDate: 10-5-3 Tooling:

QC:

Date: SPC (Y/N):

Setup Start



Stop



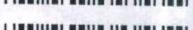
Cust Item ID:

Customer:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
----------	--------------

D3643	Rev A
-------	-------

100



Waterjet

FLOW WATER JET

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

HB 10-5-3

FLOW CNC Waterjet

Memo I-Cut as per Dwg D3643 Dwg Rev: 4 Prog Rev: 1

Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

HB 10-5-3

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

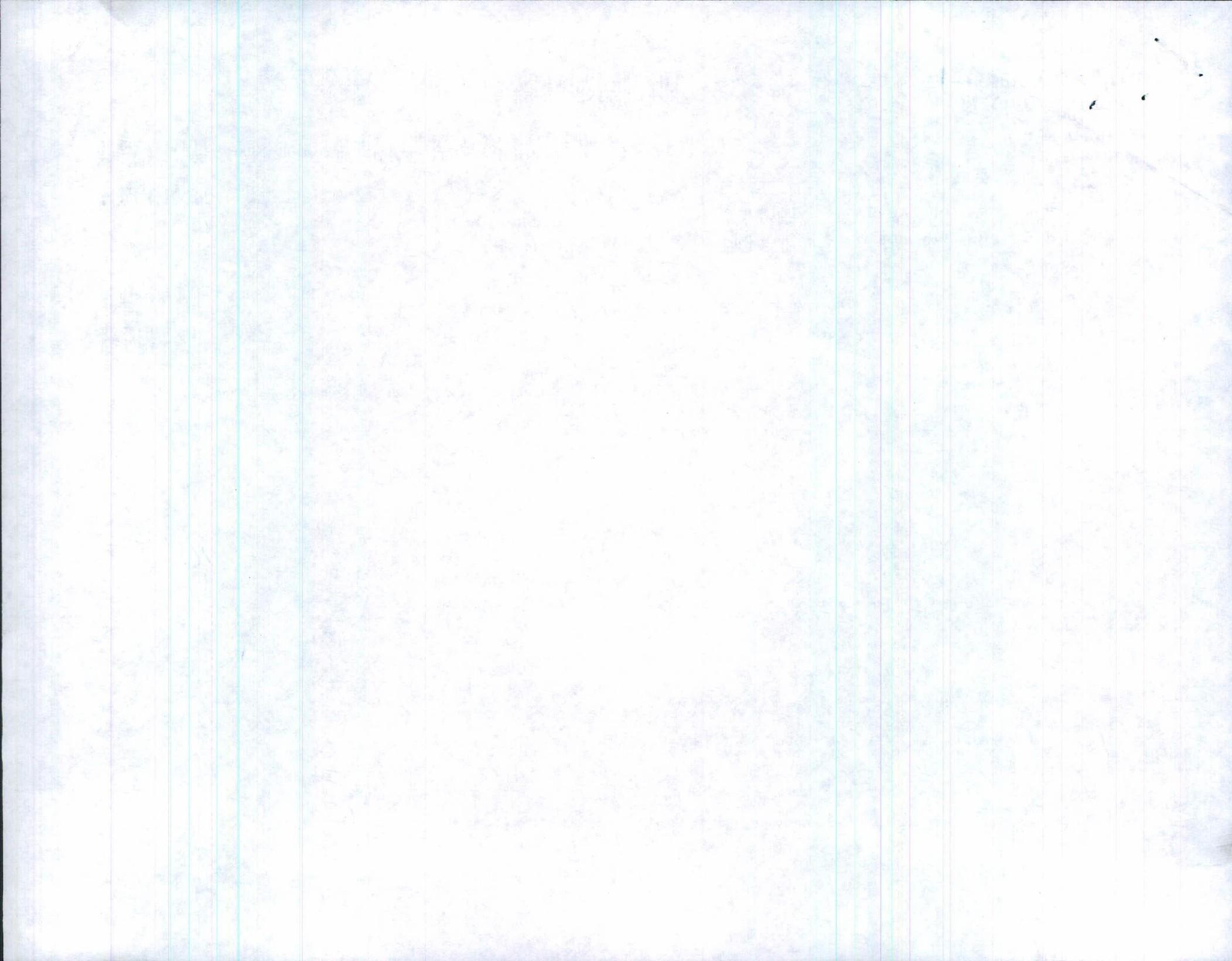
0.00

*counts
104
16*

Memo

0.00

8 w/lost 4
16



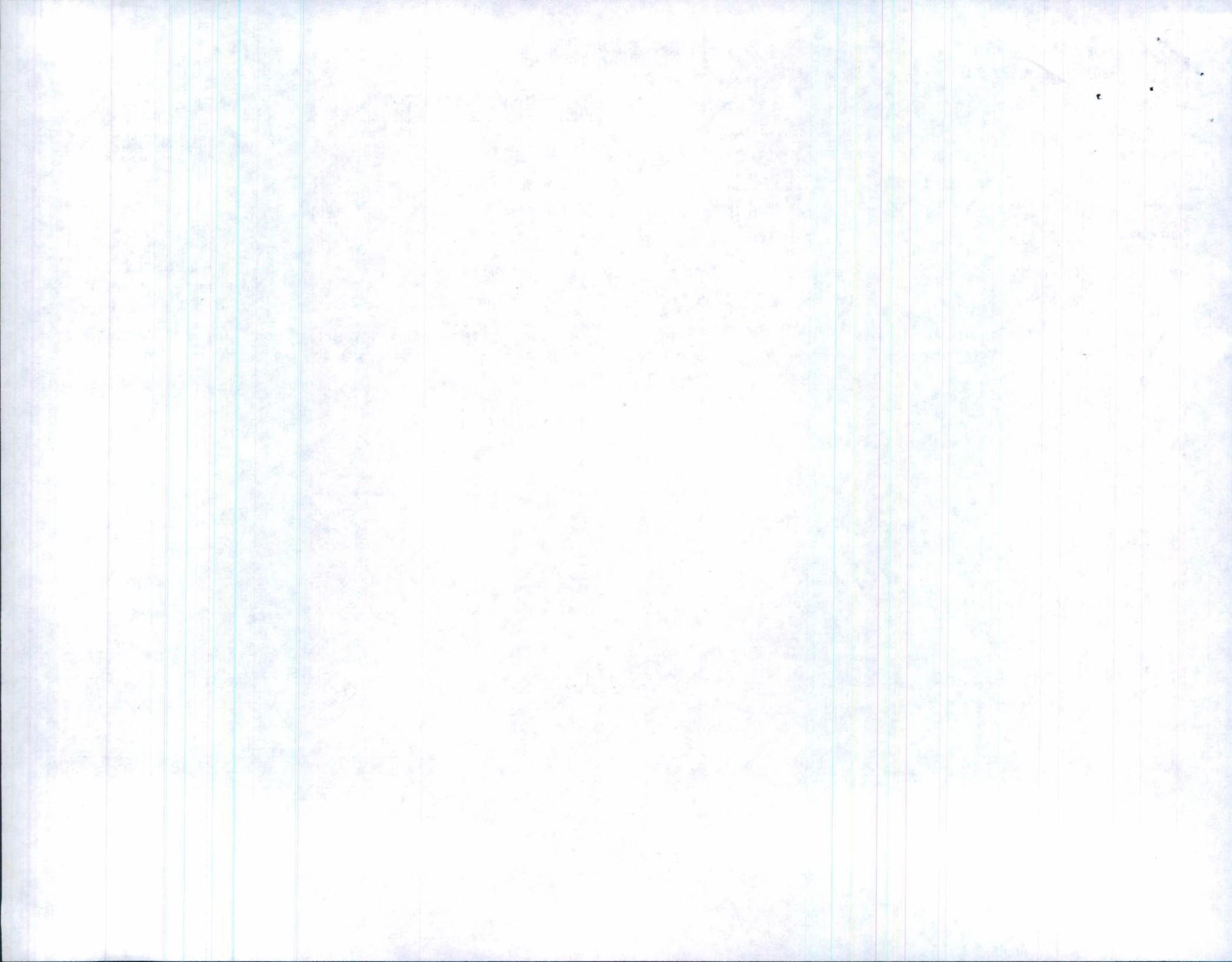
Order ID 58350

Monday, May 03, 2010 3:14:31 PM



Page 2

Item ID:	D3643-2	Accept		Setup	Start					
Revision ID:										
Item Name:	Stiffener				Stop					
Start Date:	5/4/2010	Start Qty: 10.00		Cust Item ID:						
Required Date:	5/6/2010	Req'd Qty: 10.00		Customer:						
Reference:										
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start				
	QC:	Date:	SPC (Y/N):	Date:	Stop					
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE Brake NC Brake NC	Memo Form as per Dwg D3643	0.00 0.00	S	10/05/04	D				
140 	Small Fab Small Fab Small Fab	Memo C'sink as per Dwg D3643	0.00 0.00							E5/05/04 D
150 	QC5- Inspect part completeness to step on W/O QC Quality Control	Memo	0.00 0.00	S	10/05/04	H				



Order ID 58350

Monday, May 03, 2010 3:14:31 PM



Page 3

Item ID: D3643-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 5/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

16 10/05/04

1

0

Hand Finishing

170



QC3- Inspect Part Finish

0.00

0.00

0

BL 10-5-4.

QC

Quality Control

180



Identify as per dwg & Stock Location: _____

0.00

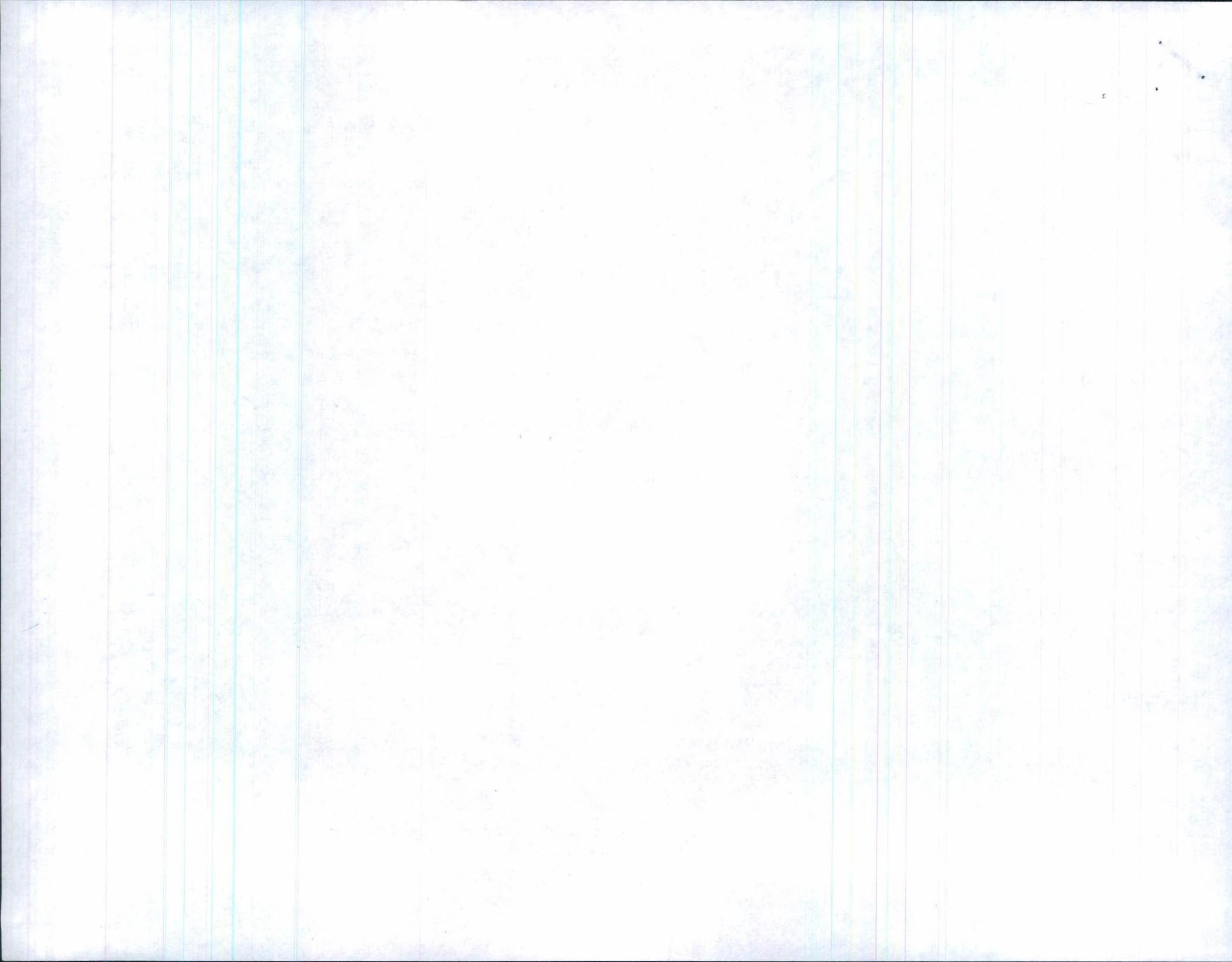
0.00

Perf 04

Packaging

Packaging

10/05/04



Work Order ID 58350

Monday, May 03, 2010 3:14:31 PM



Page 4

Item ID: D3643-2

Accept



Setup Start



Revision ID:

Item Name: Stiffener

Stop



Start Date: 5/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

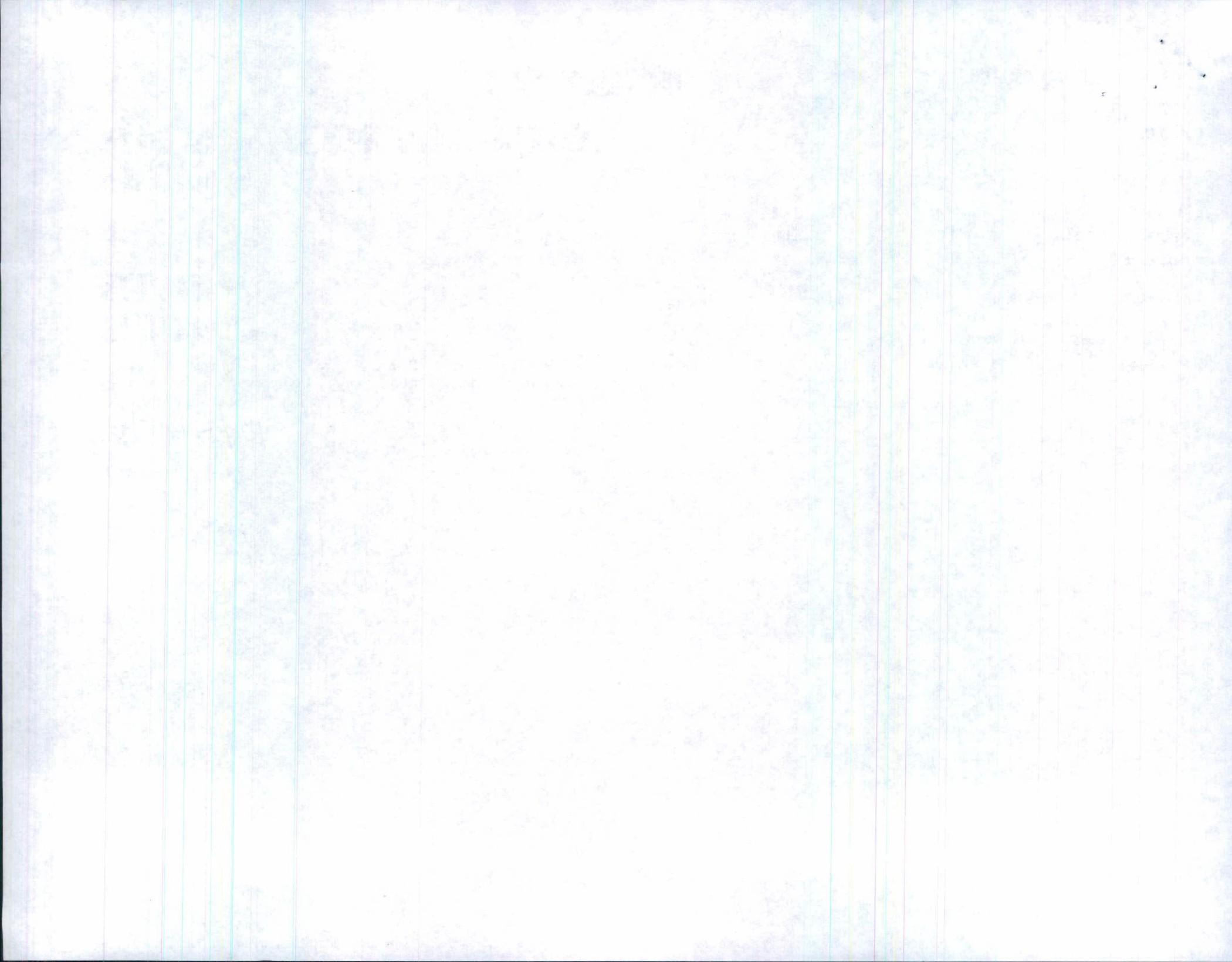
0.00

Memo

0.00

10/05/05 HJ

U 10/05-04



Print

May 03, 2010 3:14:30 PM

Page 1

Work Order ID: 58350

Parent Item: D3643-2

Parent Item Name: Stiffener

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	506.7000	0.1475			

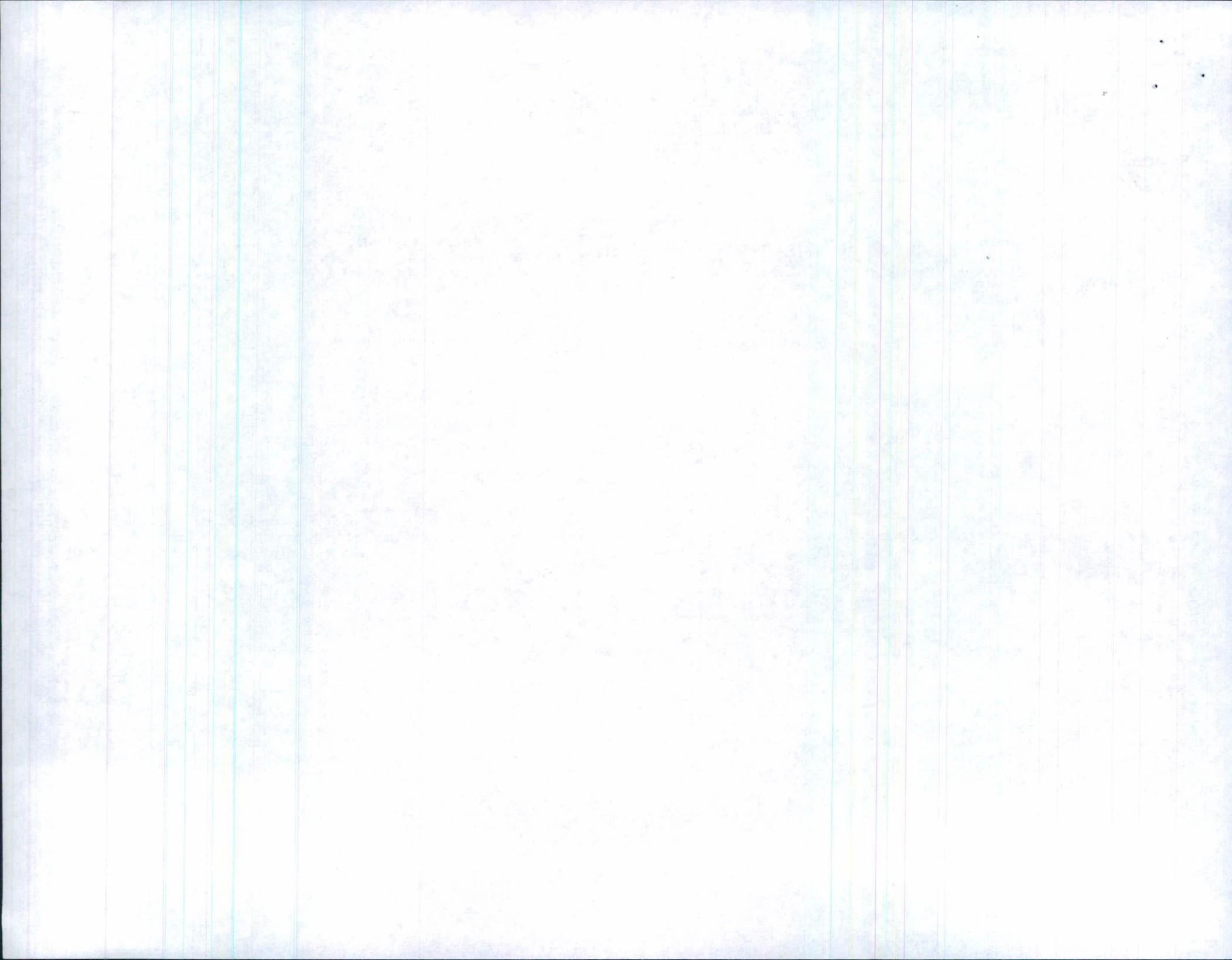
2024-T3 .040 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	96	
114415	96	
MAT22	410.7	
110305	136.7	
111786	18	
112291	32	
112331	64	
113162	160	

B10.53

(71)

111786



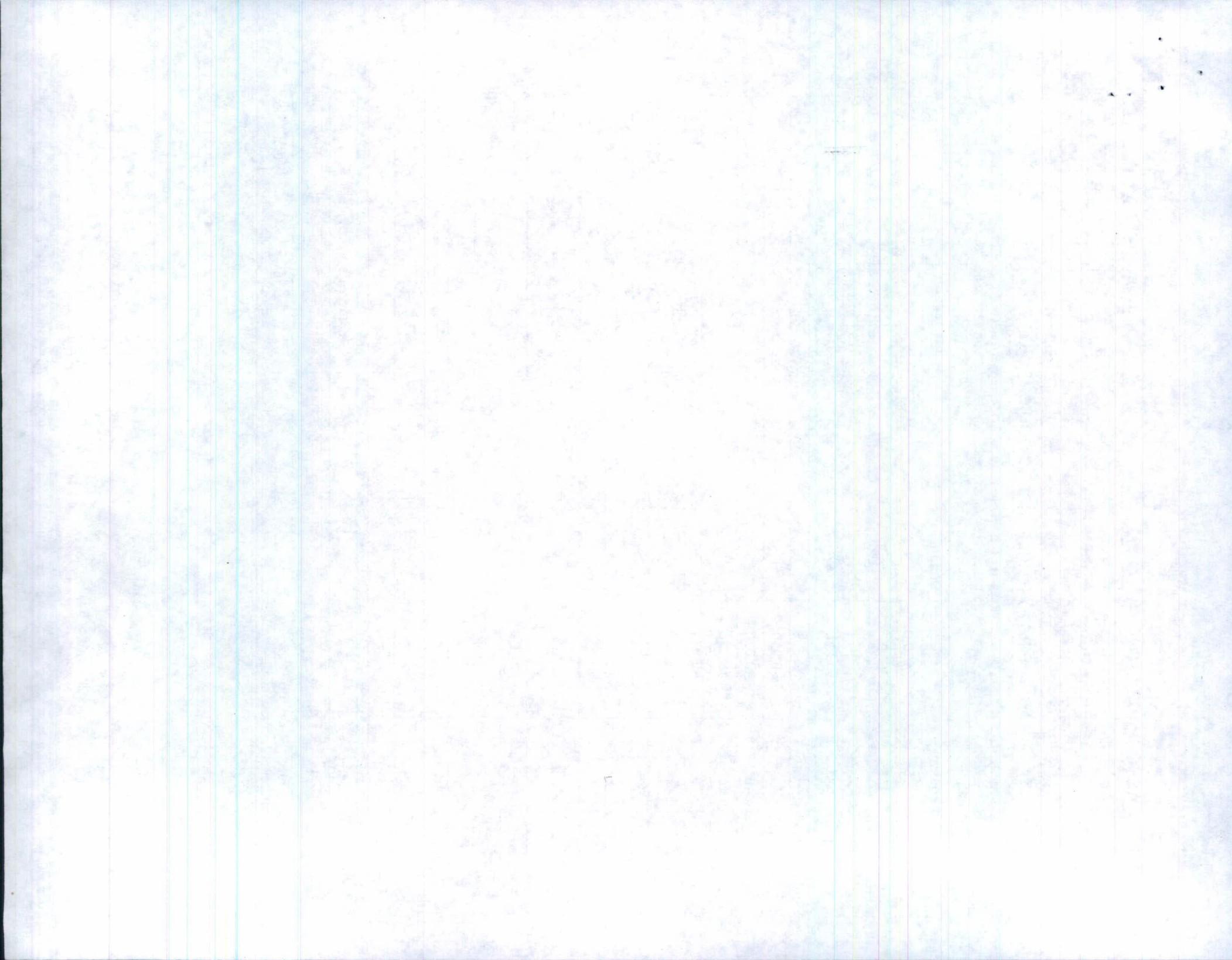
DART AEROSPACE LTD	Work Order:	58350
Description: Stiffener	Part Number:	D3643-2
Inspection Dwg: D3643 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

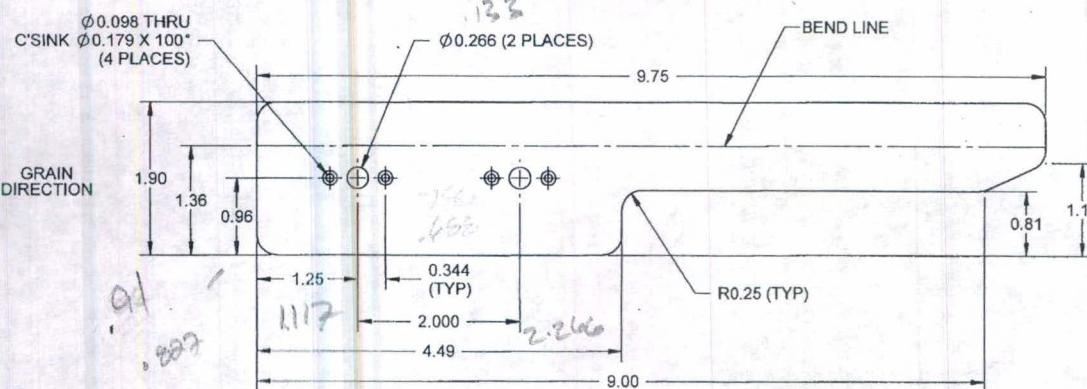
X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	0-5-3	Date:	10/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	

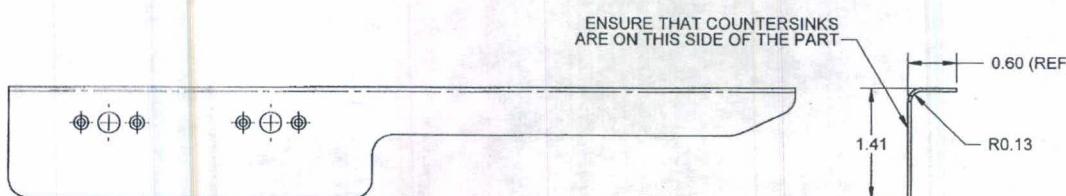


8 7 6 5 4 3 2 1



**D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)**

HS8350



**D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)**

RELEASED
07.09.07

A NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

8 7 6 5 4 3 2 1

A	NEW ISSUE; REPLACES G10610	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DTI	DART AEROSPACE LTD	
DRAWN	CJ	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZB	DRAWING NO.	REV. A
MFG. APPR.	ZB	D3643	SHEET 1 OF 1
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	STIFFENER	2:3
DATE	07.07.27	COPRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

